

Work Order ID 70535

Friday, June 10, 2011 2:54:23 PM



Page 1

Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Comfort Seat, LH/RH

Start Date: 6/10/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3800	B
DSI 9508	A
IIN D205-778	Rev B

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

03

Document Control

Photocopy bluefile & type labels per PPP D205-778-011 CHG 002

[Handwritten notes: 11 07 08 11-7-28 2]

110 0.00



Pick Kit

Packaging

Memo

0.00

Packaging

[Handwritten notes: 11/7/28 2]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC4- 100% Inspect kits for completeness	0.00				<u>11</u>	<u>11</u>	<u>07</u>	<u>28</u> (2)
QC Quality Control	Memo	0.00							
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-778-101 Location: <u>101</u> PPP Rev: <u>D</u>								<u>20</u>
140 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<u>uh/29</u>

W0729

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 70535



Parent Item: D205-778-011



Parent Item Name: Comfort Seat, LH/RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD6L Washer		Purchased	No			110	Each	928.0000	16	32			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST347				928					
					5519			928					
BSP-42 Rivet		Purchased	No			110	Each	136.0000	8	16			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST284				136					
					114598			136					
D3752-1 Seat Frame		Manufactured	No			110	Each	3.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST252A				3					
					67226			3					
D3755-041 Seat Cushion		Manufactured	No			110	Each	4.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST252A				4					
					65579			2					
					68934			2					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 70535

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

D3756-041

Manufactured No

110

Each

4.0000

Cushion

Location

Loc Qty

Loc Code

ST252A

4

65580

2

68935

2

D3758-041

Manufactured No

110

Each

13.0000

Clamp

Location

Loc Qty

Loc Code

ST081

13

58262

13

D3777-041

Manufactured No

110

Each

10.0000

Clamp

Location

Loc Qty

Loc Code

ST081

10

46659

10

D3800-3-200

Manufactured No

110

f

132.9000

Hook and Loop Strip (2" Hard)

Location

Loc Qty

Loc Code

ST083

132.9

56393

72.9

60044

60

1- Cut to length as per dwg (4x 6.00")

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 70535

Parent Item: D205-778-011

Parent Item Name: Comfort Seat, LH/RH

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

AN525-10R8

Purchased

No

110

Each

85.0000

8

16

Screw

Location

Loc Qty

Loc Code

ST325

85

114494

85

AN970-3

Purchased

No

110

Each

106.0000

8

16

Washers

Location

Loc Qty

Loc Code

ST349

106

115158

6

117395

100

AN960JD10

~~NAS1149D03631~~

Purchased

No

110

Each

0.0000

8

16

Washer

MS21042L3

Purchased

No

100

Each

2,307.000

8

16

Nut

Location

Loc Qty

Loc Code

ST300

2307

108701

12

116391

9

116549

586

117441

800

117601

400

117885

500

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W/O:		WORK ORDER CHANGES					
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4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011	13.0 lb	±22.0 in	±286 in-lb	47.0 in	611 in-lb
Comfort Seat Kit, LH / RH	5.9 kg	±0.56 m	±3.3 m-kg	1.19 m	7.0 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3756-041	CUSHION
2	D3758-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
4	D3800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1

REF TCCA STC: SH08-37

REF FAA STC: SR02704NY

REF EASA STC: EASA.IM.R.S.01518

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY -011	Part Number	Description
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY -011	Part Number	Description
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 10.03.02
CERT. NO.: SH08-37
ISSUE NO.: 1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	qp		
CHECKED	13	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9508	SHEET 1 OF 2
APPROVED	14	TITLE	SCALE
DE APPR.	14	RIVET KIT	NTS
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